



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-141
Job Sheet 167074-E



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	2017-12-13 28
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	17/12/15 06
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	17/12/15/18
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	DEC 21 2017
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	D. M. 17-12-27
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 10/01/24 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-1 5021535	1	3	0	0
	- D4636-5 5021533	1	43	0	0
	- D4647-5 5021532	1	2	0	0
	- D4664-5 5021524	6	39	0	0
	- D4712-1 5021528	1	4	0	0
	- D4732-15 5021526	1	2	0	0
	- D4732-19 5021525	1	1	0	0
	- D5021-1 5021522	1	2	0	0
	- MPNY-750S-9-C 5021521	7	570	0	0
	- MS20426AD3-4 5021520	4	5,055	0	0
	- MS20426AD4-6 5021518	2	2,797	0	0
	- MS21059L08 5021516	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____		DISPOSITION Mfg Date: 12/13/17 Job No: 167074-E		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐															
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																		
Large Fab ☐	Composite ☐	Supplier ☐																																			
 S021547 Fwd, Center Ceiling Replacement Panel Assembly		D4634 - 141 Start up Operation		QTY Effective : _____		MRB (QSI042) Approval																															
				Disposition		Completed By																															
						Lead hand / Supervisor Approval Verification																															
						QC / QA Coordinator Approval																															
Environmen Desig Doc/Dat Equip/Toolin Handling/Pr Materi Internal Transpo Tribal Knowledge LO		PART NO: Revision: Operation: Change No:		FAULT CATEGORY <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Temperature/Cure ☐</td> <td style="width: 33%;">Power Loss/Surge ☐</td> <td style="width: 33%;">Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																			
Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																			
BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																			
Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																			
Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																			
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																			
Countersink ☐	Off-set ☐	Drawing ☐																																			
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																			
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																			
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																			
Substation Past Expiry Date Misidentified		Manufacturing Process Past Due		OTHER : _____																																	